



Dart Aerospace Ltd.
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fash

D4776-1
Job Sheet 176032



Part No: **D4776-1**

Job Qty: 24 ea

Part Name: Basket Strut Clevis



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 4/16/18

Job Tracking No:

Due Date: 4/19/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV D SHEET 1 IPP REV:A 13.02.28 NEW ISSUE DD VERF:JFS IPP REV:B 13.09.26 AS PER REV.B
DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	24 Ea	4/18/18	4/18/18	0.00	0.00	Start Up Machining-3		<i>M.P. 18/04/24</i>
100	Doosan	24 pcs	4/18/18	4/18/18	0.54	12.77	Doosan		<i>M.P. 18/04/24</i>
105	QC	24 pcs	4/18/18	4/18/18	0.00	0.00	QC2 Machining-3		<i>M.P. 18/04/24</i>
111	QC	24 pcs	4/18/18	4/18/18	0.00	0.00	QC8 Machining-3		<i>M.P. 18/04/24</i>
112	HandFinish	24 pcs	4/18/18	4/18/18	0.00	0.69	HandFinish1		<i>SA 18-04-25</i>
113	QC	24 pcs	4/18/18	4/18/18	0.00	0.00	QC7-4		<i>BR 18-4-26</i>
115	Powdercoat	24 pcs	4/19/18	4/19/18	0.00	0.28	Powdercoat1		<i>BR 18-4-26</i>
116	QC	24 pcs	4/19/18	4/19/18	0.00	0.00	QC3		<i>BR 18-4-30</i>
130	Packaging	24 pcs	4/19/18	4/19/18	0.00	0.00	Packaging3-2	<i>STILL</i>	<i>SD APR 30 2018</i>
140	QC21-SA	24 Ea	4/19/18	4/19/18	0.00	0.00	QC21		<i>21 APR 30 2018</i>

Part Op 100 - 1- Turn as per Folio FB167 Dwg D4776 Rev: 2

Descriptions: 115 - MASK .403 ROUND SECTION AS PER DWG

M/38760 START: 7:40. O.V.T: 300° FINISH: 8:10.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R1.500	6061-T6 Round Bar 1.50	6.9600 ft (.29 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6R1.500	7	26	0

QA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Basket Strut Clevis	0.880Inches ± 0.030	0.877 0.850		
2	Basket Strut Clevis	0.438Inches ± 0.010	0.437 0.428		
3	Basket Strut Clevis	0.380Inches ± 0.030	0.379 0.350		
4	Basket Strut Clevis	0.625Inches ± 0.010	0.625 0.615		
5	Basket Strut Clevis	1.750Inches ± 0.030	1.750 1.720		
6	Basket Strut Clevis	3.500Inches ± 0.030	3.502 3.470		
7	Basket Strut Clevis	45.000Degrees ± 0.500	45 44.500	Angle	
8	Basket Strut Clevis	0.030Inches ± 0.030	0.030 0.000		
9	Basket Strut Clevis	0.060Inches ± 0.030	0.060 0.030	Radius	
10	Basket Strut Clevis	0.196Inches + 0.006 - 0.001	0.199 0.195	Diameter	
11	Basket Strut Clevis	0.261Inches + 0.006 - 0.001	0.263 0.260	Diameter	
12	Basket Strut Clevis	0.410Inches ± 0.030	0.41 0.380	Radius	
13	Basket Strut Clevis	1.130Inches ± 0.030	1.126 1.100		
14	Basket Strut Clevis	0.188Inches ± 0.010	0.186 0.178		
15	Basket Strut Clevis	0.190Inches ± 0.030	0.189 0.160		
16	Basket Strut Clevis	0.500Inches ± 0.030	0.500 0.470		
17	Basket Strut Clevis	0.750Inches ± 0.010	0.750 0.740		
18	Basket Strut Clevis	0.403Inches + 0.000 - 0.005	0.402 0.398	Diameter	
19	Basket Strut Clevis	0.130Inches ± 0.030	0.130 0.100	Radius	
20	Basket Strut Clevis	0.750Inches + 0.010 - 0.000	0.754 0.750		
21	Basket Strut Clevis	0.160Inches ± 0.030	0.160 0.130		
22	Basket Strut Clevis	45.000Degrees ± 0.500	45 44.500	Angle	

Plex 4/16/18 7:46 AM dart.lacelle.linda

QQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
Description Work Order Deviation		Disposition	
			Completed By
			Lead hand / Supervisor Approval Verification
			QC / QA Coordinator Approval

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Date: 04/24/18



Container No: S064489
 Part: D4776--1
 Job No: 176032
 Serial No/Batch: S064489
 Revision:
 Inspector:

FAULT CATEGORY

Defect	☐	Power Loss/Surge	☐	Positioned Wrong
	☐	Folio/Program	☐	Outside Dimensions
	☐	Grain	☐	Over/Under tolerance
	☐	Weld	☐	Part Incorrect
	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Delete/Unqualified	☐	Out of Sequence	☐	Part Moved
	☐	Off-set	☐	Drawing
	☐	Mislabeled	☐	Finish
	☐	Fit/Function	☐	Misread
	☐	Misaligned/off center	☐	Turning Sequence